

Work Order ID 69180-2

Wednesday, May 04, 2011 8:40:10 AM

Page 1

Item ID: D3394-043

Revision ID: 3

Item Name: Lug Assembly

Start Date: 5/4/2011

Start Qty: 36.00

Required Date: 5/13/2011

Req'd Qty: 36.00

Reference:

Approvals: Process Plan: CL

Date: 11/05/04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3394 DEO

Rev B

0.00

100



Bandsaw

Jeep's Bandsaw

BANDSAW

Memo

Cut Blank to .850"

0.00

cut @ meter

0.00

120



HAAS I

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND TOLRD FA808
TOLRD REV
DWG REV

0.00

issue P10 to meter

DEBUTER

machine as per drawing D3394-B

REV. 13

P10:14001

CL 11/05/04 36

CL 11/05/04 36

split

Accept

3

Paint Blue

4



Cust Item ID:

Customer:

Setup Start

Stop



Work Order ID 69180

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Page 2

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 5/4/2011 Start Qty: 36.00

Required Date: 5/13/2011 Req'd Qty: 36.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



QC
Quality Control

QC2-Inspect parts off machine FA/TAB

0.00

Memo

0.00

rec'd + inspect for transit damage
attached cab to wro

CY 11/05/04 36

11/17 32



QC
Quality Control

QC2-Inspect parts - second check

0.00

Memo

0.00

5 weeks

count
(136)



Hand Finish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

X36 0 11/05/19

Work Order ID 69180

Wednesday, May 04, 2011 8:40:10 AM

Page 3

Item ID: D3394-043

Accept



Setup Start

Revision ID:

Item Name: Lug Assembly

Stop

Start Date: 5/4/2011 Start Qty: 36.00

Required Date: 5/13/2011 Req'd Qty: 36.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

150

White Ref. 4.3.5.1 per QSI005 4.3-Alum

0.00



Paint blue

Memo

0.00

Powdercoat

START TIME

OVEN TEMPERATURE

FINISH TIME

11/1/11
11/1/11
11/1/11

57

11

05

25

31

160

QC3-Inspect Part Finish

0.00



12-14

Memo

0.00

QC

Quality Control

18

11

05

26

36

170

Small Fab

0.00



Memo

0.00

Small Fab

Assemble in part Dwg D3394

N/A

12

18/05/11

Work Order ID 69180

Wednesday, May 04, 2011 8:40:10 AM



Page 4

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 5/4/2011 Start Qty: 36.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 36.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC'S- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

190

Identify as per dwg & Stock Location: 420

0.00



Packaging

Memo

SHL ID 05
D3394-3

0.00

Packaging

200

QC 21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/26 70

for new
steps
200-618/0268L

11/5/30 48

11/5/26

Picklist Print

Wednesday, May 04, 2011 8:40:07 AM

Page 1

Work Order ID: 69180

Parent Item: D3394-043

Parent Item Name: Lug Assembly



Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS35489-93



GROMMET

Purchased

No

100

Each

351.0000

2

72

Location

Loc Qty

Loc Code

ST246

351

116235

351

D2423



Lug Extrusion

Manufactured

No

110

1

342.8400

0.07

2.652632

Location

Loc Qty

Loc Code

MA1006

342.84

43722

161.5

45800

1

63005

180.34

D3394-3P



Lug

Purchased

No

170

Each

0.0000

1

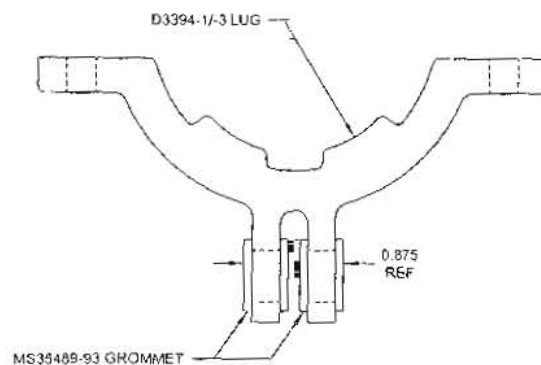
36

CZ11/05/04

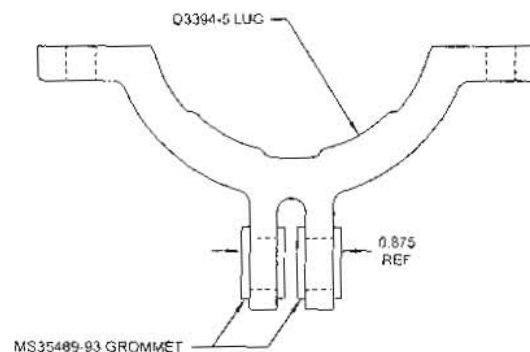
265

Perf 11 (36)

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

DEO ATTACHED

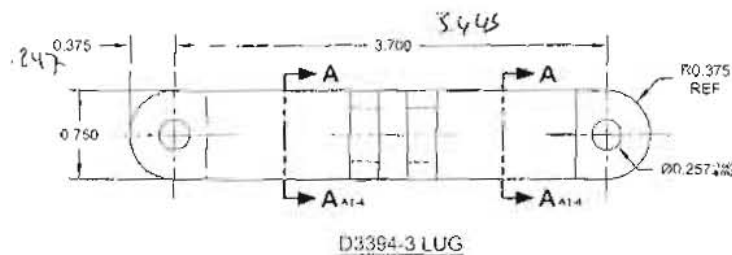
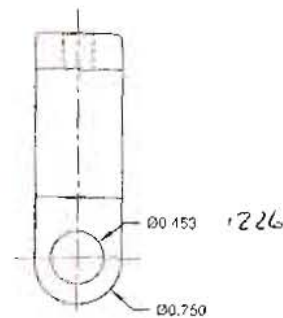
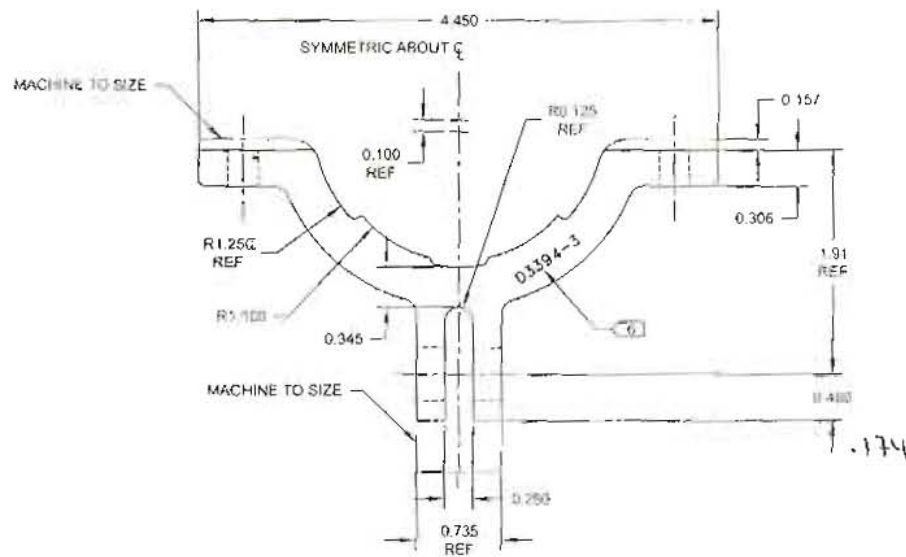
RELEASED
69/6/15/ND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

*12/11/03/04
w/c 69/80*

B	ADDED -045 SHT & ADDED FILLETS IN SECTION A-A SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DESIGN NO.	REV B
MFG APPR		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS SPECIFICALLY DESIGNED.	



DEO ATTACHED

RELEASED
09/06/25/10

NOTES:

- 1) MATERIAL: MAKE FROM 02423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAH1 Q31 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART Q31 005 4.3
- 3) TOLERANCES: PER DART Q31 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.003 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

W10.69180

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. B
ENG. APPR		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
BY APPR		LUG	NTS
DATE	09 04 02	COPYRIGHT © 2002 BY DART AEROSPACE LTD	

DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04			

SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



ROUND SHARP EDGE
R0.06 - 0.10
2 PL

SECTION A-A

WAS:



R0.125
2 PL

SECTION A-A

W/O: 69180

RELEASED
2009-11-25
W/D

REASON: DRAFTING ERROR

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO#001**

Purchase Order Date 5/4/2011

PO Print Date 5/4/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Chantal Lavoie

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2731-7P	LUG	5/13/2011 Yes	36.00 Each	Dart Truck	\$13.9000	\$500.40
		Special Inst:	MACHINE AS PER DWG D2731 REV. C B69177				
2	D3394-3P	Lug	5/13/2011 Yes	36.00 Each	Dart Truck	\$18.9500	\$682.20
		Special Inst:	MACHINE AS PER DWG D3394 REV. B B69180				
3	D2230-1P	LUG	5/13/2011 Yes	100.00 Each	Dart Truck	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B69179				

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

PO Total:

\$3,077.60

Change Nbr: 1

Change Date: 5/4/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

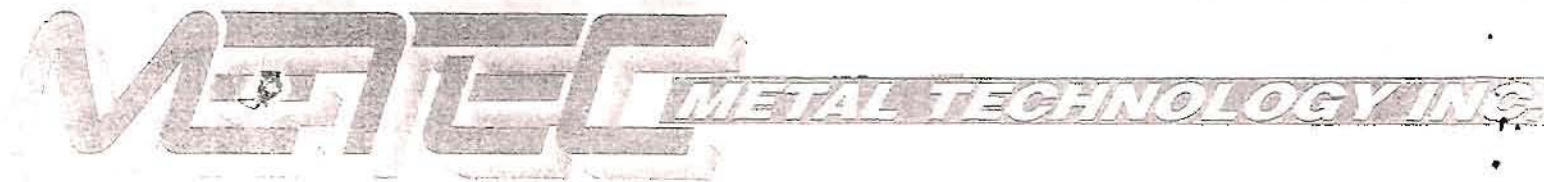


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0, Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17970
Date: May 16, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14001	Sold By: Welz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 Lug Material supplied by DART: D2423 B63005	Each	36	36	
D3394-3 Lug Material supplied by DART: D2423 B63005 <i>Swister</i>	Each	36	36	
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		100
<p>The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.</p>				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd
70 Aberdeen Street
Hawkesbury, Ont
K6A 1K7

SHIPPED TO:

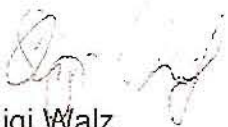
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
36	D2731-7P	Lug	14001
36	D3394-3P	Lug	14001

MATERIAL supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc


Shigi Walz

Vankleek Hill, May 16, 2011

